DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026972
Date Inspected: 28-Dec-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Westmont Industries

OSM Arrival Time: 600
OSM Departure Time: 1430
Location: Santa Fe Springs, CA

CWI Name: Chris Concha

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: Maintenance Travelers

Summary of Items Observed:

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

Maintenance Traveler Console Panels (Test)

This QA noted that Hydraulic Controls, Mr. Roy Scott, was on site at WMI to test and inspect the pneumatic system inside the Traveler Console Panels that had been assembled by Zemarc Corporation. Also, observing testing, Zemarc Corp. Mr. Carlos Aguirre, Ty Lin Mr. Andrew Baumberger, Ty Lin Mr. Roy Frether and WMI Mr. Ray Meier.

Miscellaneous Mechanical

This QA Inspector randomly observed Westmont Industries (WMI) production welder, Mr. Daniel Grayum (WID # 3049), performing fitting and welding activities on material, for the Traveler Navigation Light Mounts A950 & B950. Mr. Grayum was observed fitting and tack welding using approved Flux Cored Arc Welding (FCAW) process, welding in 2F position.

SAS Travelers Supplementary Platforms

This QA Inspector made random shop observations and observed no fit-up performed on the SAS Travelers Supplementary Platforms Assemblies on this date.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present,

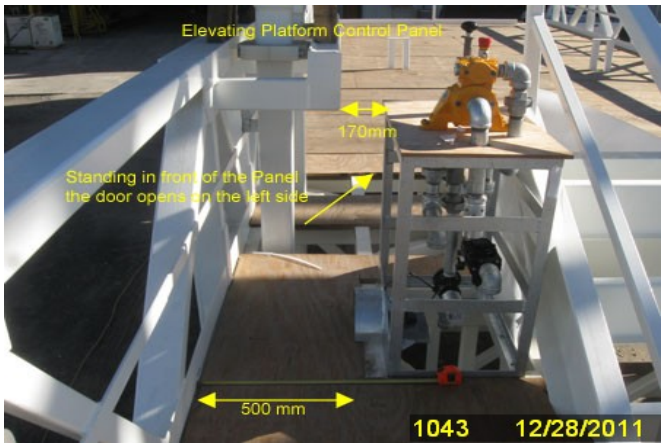
during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to continue coat applications on Maintenance Travelers. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to abrasive blast SAS EB/WB Balconies, Traveler Trolley Links, Anti-twist assemblies today. Later in the morning this QA Inspector randomly observed that RPI personnel performing abrasive blasting activities on the above mentioned components. Mr. Keen stated that RPI will not apply the Zinc Clad II plus prime coating the SAS EB/WB Balconies, Traveler Trolley Links, or anti twist beams today. Note #1: The SAS EB/WB Balconies had been previously abrasive blasted and prime coated, but due to balcony modifications, balconies were re-blasted. Note #2: The Traveler Trolley Links had been previously abrasive blasted, prime and top coated, but due to Traveler brake modification, links were re-blasted in preparation for welding.

This QA performed a DFT (dry film thickness) survey of the SAS WB Traveler on the Sherwin Williams, Zinc Clad II Plus prime application. Zinc Clad II Plus prime application had been spray applied by RPI Coating. A total of thirty one measurements on the SAS WB Traveler, were taken randomly throughout the structure in accordance with SSPC PA2 criteria. The overall average was in compliance with the contract requirements of 90 microns to 150 microns. The prime coat was found to be well cured and to generally meet the contract requirements.

This QA noted above items observed appear to comply with contract documents.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer